

Work Order ID 53175



Page 1

October 26, 2009 9:03:29 AM

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skid tube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

BT

Date:

09-10-26

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

H for CL 09/11/10

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP
9-10-28

Work Order ID 53175

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Item ID: D205-634-041

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Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Item ID: D205-634-041
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Setup Start



Stop



Start Date: 26/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004.
A/R□□□ Aluminum Rod

mill 999

BE 09/10/29

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

mill 999

BE 09/10/29

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208", Deburr

7-Drill pilot holes for Towing using DT8091, open to .640" and Deburr

BE 09/11/02

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Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

⇒ Sorluloz



/

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

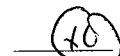


QC

Memo

0.00

⇒ Sorluloz



/

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

⇒ M Sorluloz



/

Hand Finishing

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Accept

**Setup Start**

00000000000000000000

D

Stop

Abstract

Abstract

Cust Item ID:

Customer:

Reference:

Run Start

Abstract

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

RESEARCH DESIGN

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 1040 1041 1042 1043 1044 10

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 112148

0.00

$$= 4 \text{ 09/11/04}$$

41



190

00000000000000000000

QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

MO 09/11/04

x1

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Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/28

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/28

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: A112106

m-h 09/11/09

(IX)

X1

MO 09/11/11

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Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00				<u>ml</u>	<u>09</u>	<u>11</u>	<u>09</u> ①
QC Quality Control	Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00							
220 	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPPD205-634-041 Location: <u>13</u> PPP Rev: <u>1</u>	0.00							<u>09/11/10</u> <u>09/11/10</u> ①
230 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<u>09/11/10</u> ② <u>MF</u> <u>09-11-10</u>

53175

Picklist Print

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Work Order ID: 53175



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	0.0000	1.0000			
205 Skidtube bent detail												
D2576-3RevG		Manufactured	No			140	Each	169.0000	1.0000			
Step (maching detail)												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

169

43504

21

46661

101

52215

47

D2579RevE

Manufactured No

140

Each

695.0000

20.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

573

51525

573

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

1 BE 09/10/29

+20 BE 09/10/29

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Work Order ID: 53175



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			200	Each	106.0000	1.0000			

Cap



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

106

50513

1

50770

5

51539

100

XI m009/11/06

AN3-5A

Purchased

No

200

Each

2,249.000 2.0000

Bolt



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2249

100188

188

105057

2061

X2 m009/11/06

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Work Order ID: 53175

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L 		Purchased	No			200	Each	5,949.000	2.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5949	
101291	16	
104885	153	
105793	236	
109632	544	
110985	5000	

X2 MD 09/11/06

ALS7-1032-130

Purchased

No

200

Each

2,234.000 50.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2234	
105855	16	
108606	52	
111529	1488	
111779	313	
112772	365	

110511

X50 MD 09/11/06

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Work Order ID: 53175



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			200	Each	1,474.000	50.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1474	
112314	13	
112720	12	
112724	3	
112794	846	
112829	500	
112991	100	

X50 m009/11/00

AN960C10L



washer

Purchased

No

200

Each

4,868.000 50.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4768	
112116	876	
112612	2892	
112933	1000	

X50 m009/11/00

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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13RevC		Manufactured	No			200	Each	33.0000	1.0000			

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

31

51606

31

Main Warehouse

ST

2

45717

1

50265

1

X1 mD 09/11/06

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Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			200	Each	37.0000	1.0000			
Gasket												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	12	
(51929)	12	
Main Warehouse		
FP19	21	
51669	1	
52909	20	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

XI mo 09/11/09

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Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			200	Each	26.0000	2.0000			

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

21

52512

21

Main Warehouse

ST

5

46349

1

51218

1

51259

3

X2 mo 09/11/06

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Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	46.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	11	
51905	11	
Main Warehouse		
FP19	33	
51594	10	
52125	23	
Main Warehouse		
ST	2	
45823	1	
50112	1	

XI MD 09/11/00

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Parent Item Name: Replacement Skidtube


Comments:

Start Date: 26/10/2009

Required Date: 10/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	56.0000	1.0000			
												
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	44	
51611	33	
52059	11	
Main Warehouse		
ST	12	
45409	2	
46495	10	

XI MD 09/11/06

D3564-9RevD

Manufactured No

200

Each

10.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	8	
51675	8	
Main Warehouse		
ST	2	
44659	1	
45825	1	

XI MD 09/11/06

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Work Order ID: 53175



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	37.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	18	
51655	10	
51925	8	
Main Warehouse		
ST	17	
45824	1	
47433	1	
52595	15	

X1 MD 09/11/09

D2594-3RevC

Manufactured No

200

Each

1,050.000 16.0000



O-Ring, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	50	
51613	50	
Main Warehouse		
ST	1000	
52562	1000	

X16 MD 09/11/09

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Work Order ID: 53175



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	601.0000	16.0000			

Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	601	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	479	

X16 MD 09/11/06

DART**RELEASED**
07-06-28 #

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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BT 09-10-26

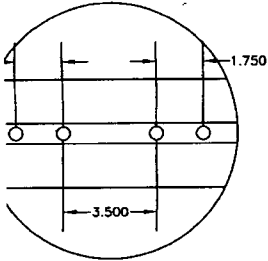
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

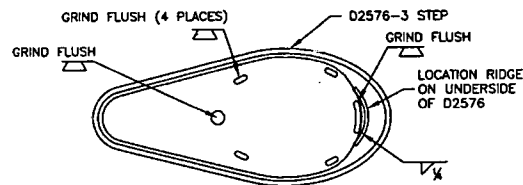
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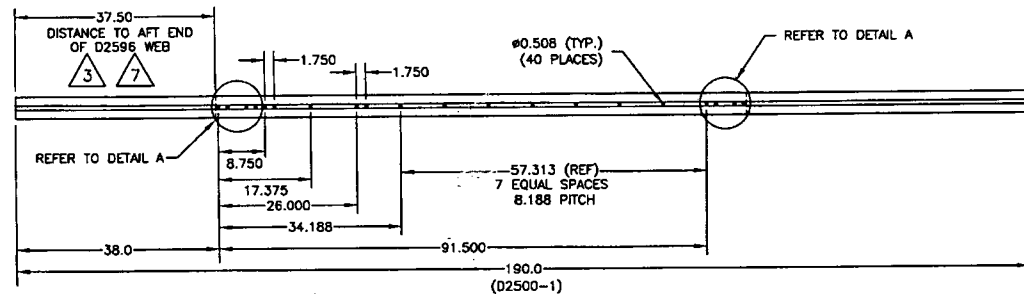
DETAIL A
SCALE 5:24



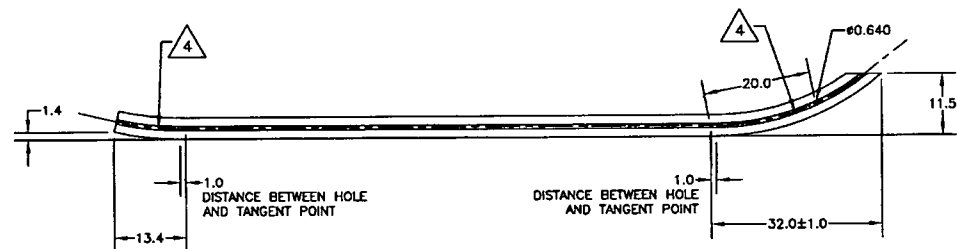
DETAIL B
SCALE 5:24



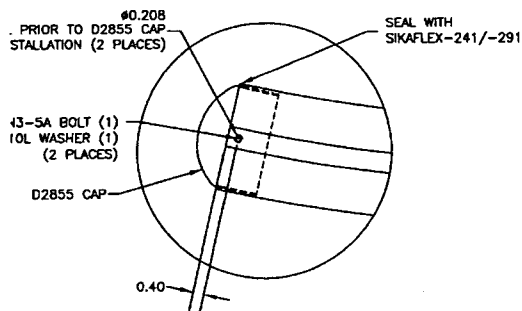
D2580-1 DRILLING DETAIL



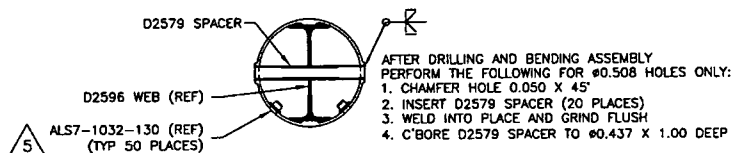
D2580-1 BENDING AND CUTTING DETAIL



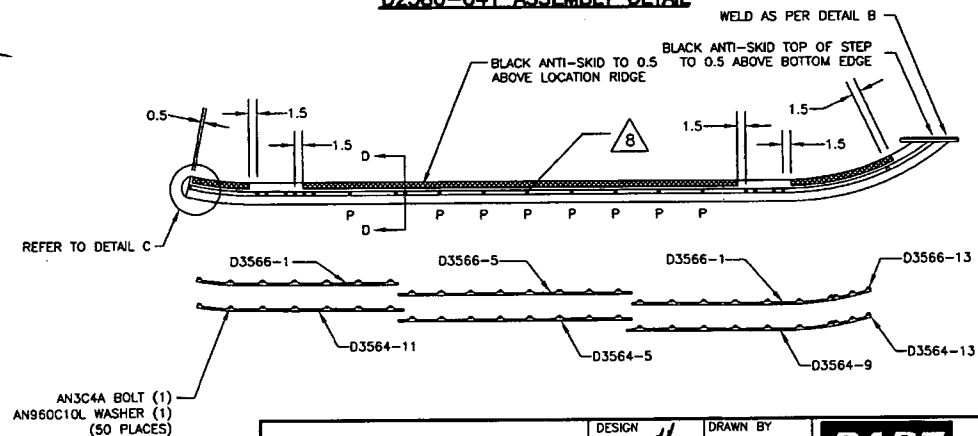
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



-041 NOTES

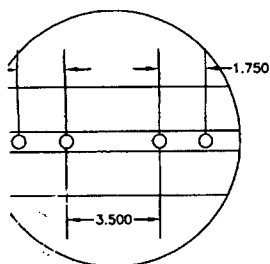
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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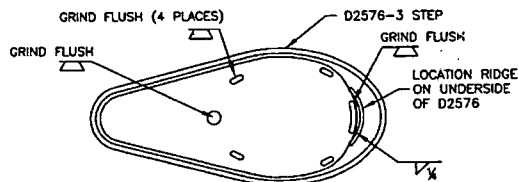
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CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE	TITLE	D2580	SHEET 2 OF 3
07.02.27	205 SKIDTUBE ASSEMBLY		SCALE 1:24

DETAIL E
SCALE 5:24

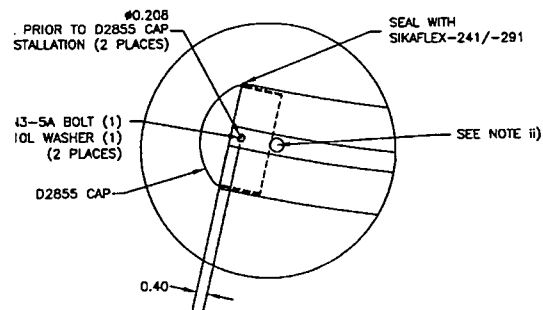


DETAIL F
SCALE 5:24

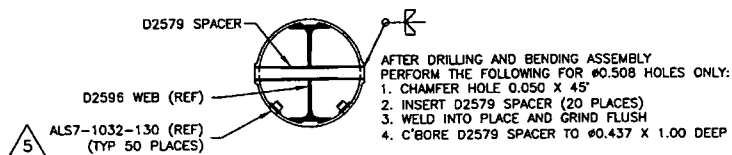


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DETAIL G
SCALE 5:24

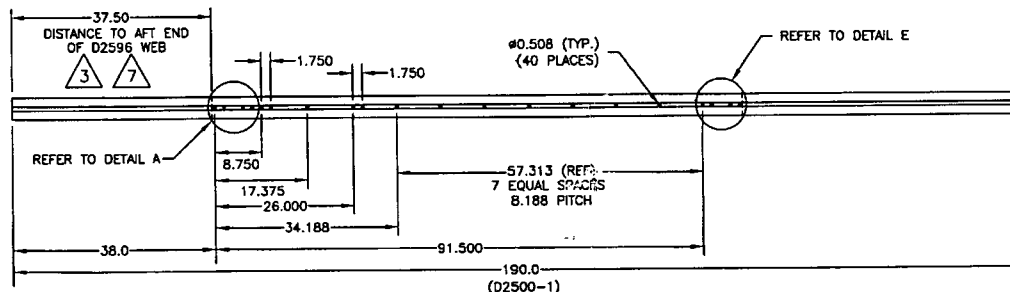


SECTION H-H
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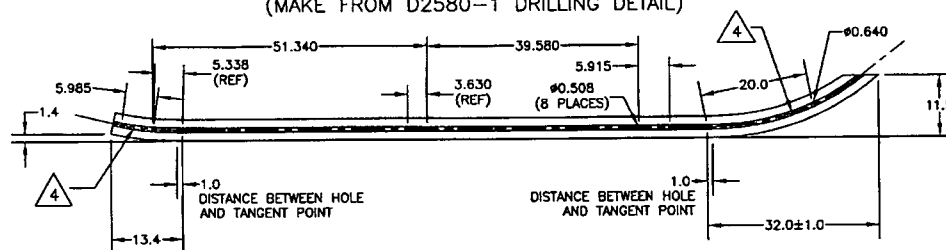


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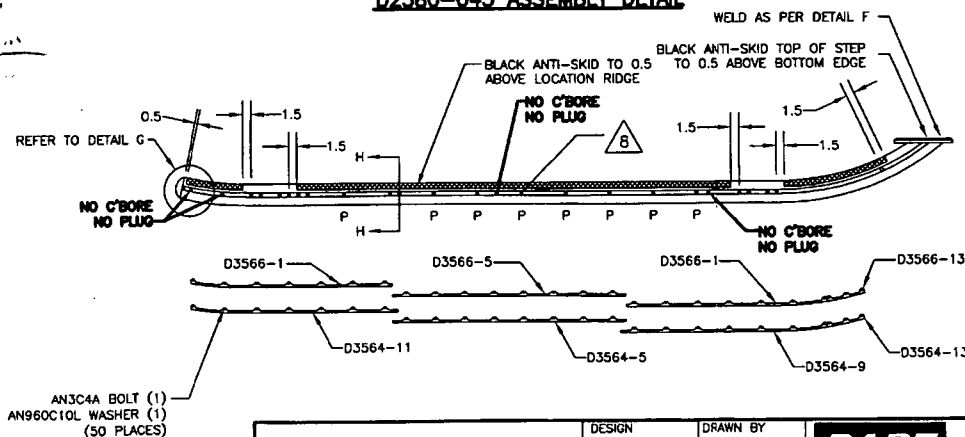
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



-045 NOTES

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

NO. 215

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 53175
Part number: D205-634.041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 04.11.02

Welder [Signature] Date of Test Coupon 09.11.02

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

